

Work Order ID 148064

148064

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June 22, 2016 11:58:42 AM

Item ID: D3608-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Doubler

Start Date: 6/22/2016 Start Qty: 6.00 ***6***

Cust Item ID:

Required Date: 6/29/2016 Req'd Qty: 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: SH Date: 6/22/16 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3608	D								
100		0.01							
100	FLOW WATER JET								
Waterjet	Memo	0.14							
FLOW CNC Waterjet	1-Cut as per Dwg D3608 Dwg Rev: <u>D</u> Prog Rev: <u>D</u> 2-Deburr if necessary								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.01							
Quality Control									
120		0.00							
120	QC8- Inspect parts - second check								
QC	Memo	0.02							
Quality Control									

PR 2016/06/25

8

PR 2016/06/26

8

8

DAS
38
9-89

JUN 28 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

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Item ID: D3608-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Upper Doubler

Start Date: 6/22/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/29/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: S222

0.00

150

Packaging

Memo

0.01

JUN 28 2016

DAS
6
9-28

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.10

Quality Control

16/6/29

SA 6/28/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

Picklist Print

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Work Order ID: 148064

148064

Parent Item: D3608-3

D3608-3

Parent Item Name: Upper Doubler

Start Date: 6/22/2016

Required Date: 6/29/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-03-26 JLM
IPP Rev:B 08-10-15 preliminary issue DD verified by:EC
IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP
Rev:D 10.02.16 rev.B as per dwg DD verified by:EC IPP Rev:E
10.11.17 as per PC1 dwg DD verified by:EC IPP Rev:F 10.11.29 as
per revC dwg DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	125.2210	0.7392	4.668632			

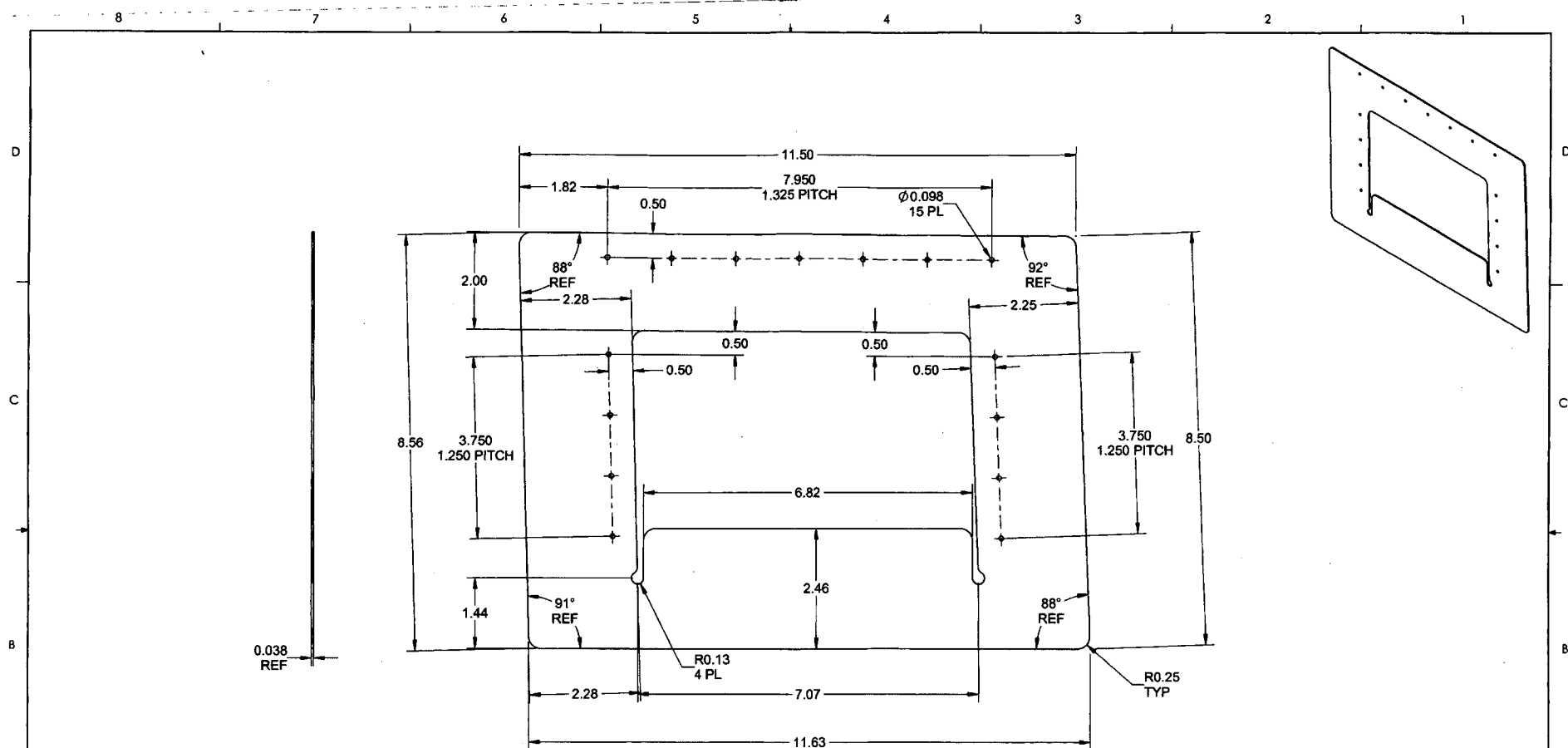
M304S20GA

304/316 .040 Sheet

PR 2016/06/26

Location	Loc Qty	Loc Code
MAT020	122	
m134399	2.2	
m134495	37	
m134677	18.8	
m134982	64	
MAT20	3.221	
m133901	3.221	

6



D3608-3 UPPER DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASTM A240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044611
- 7) WEIGHT: 0.75 lbs

RELEASED
2016-06-16

APPROVED

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	CC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JLM	D3608	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DOUBLER	NTS
DATE	16.03.01	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		Work Order:	148064
Description: Upper Doubler		Part Number:	D3608-3
Inspection Dwg: D3608 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.099	✓		Dc-01	
1.82	+/-0.030	1.812	✓		Dc-02	
0.50	+/-0.030	0.510	✓			
11.50	+/-0.030	11.513	✓			
7.950	+/-0.010	7.951	✓			
1.325	+/-0.010	1.328	✓			
2.25	+/-0.030	2.261	✓			
8.50	+/-0.030	8.516	✓			
3.750	+/-0.010	3.750	✓			
1.250	+/-0.010	1.254	✓			
6.82	+/-0.030	6.819	✓			
2.46	+/-0.030	2.466	✓			
7.07	+/-0.030	7.073	✓			
11.63	+/-0.030	11.632	✓			
2.28	+/-0.030	2.290	✓			
1.44	+/-0.030	1.443	✓			
8.56	+/-0.030	8.566	✓			
2.00	+/-0.030	2.010	✓			
0.040	+/-0.010	0.038	✓			

Measured by: PR / dc	Audited by: DAS 38	Preliminary Approval:
Date: 2016/06/25	Date: JUN 28 2016	Date:

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	10.02.18	Dimensions updated per Dwg Rev B	KJ	
C	10.12.21	Dimensions updated per Dwg Rev C	KJ	